

# Work Order ID 71008

Tuesday, June 21, 2011 9:01:01 AM



Page 1

Item ID: D2803-042

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/20/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-2 and D2809 into arm as per Dwg D2803

9/5/06/23 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/06/23

(+2)

-012

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00

3200

2:30

2x Ø M 24/06/23

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				2		BK 11-6-23	
150  Small Fab Small Fab	Small Fab  Memo Assemble as per Dwg D2803.	0.00  0.00							
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							

W/O:		WORK ORDER CHANGES					
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Item ID: D2803-042

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Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/20/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Packaging

Identify as per dwg & Stock Location: 2T147

0.00

Memo

0.00

Packaging

JB 2/c (2) 11/06/24

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/6/27 JF

MF  
11-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 9:01:07 AM

Page 1

Work Order ID: 71008

Parent Item: D2803-042

Parent Item Name: Bracket Assembly



Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP F05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-2  Bracket		Manufactured	No			100	Each	2.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST148				2					
					56187			2					
D2805-2  Stop		Manufactured	No			100	Each	2.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				2					
					64454			2					
NAS1515H3  Washer		Purchased	No			100	Each	96.0000	4	12			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST277				96					
					116373			6					
					117460			90					
AN3C16A  Bolt		Purchased	No			150	Each	29.0000	2	6			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST352				29					
					115835			29					

*Handwritten notes and signatures:*  
 3  
 2  
 3  
 2  
 12  
 6  
 4  
 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, June 21, 2011 9:01:07 AM

Page 2

Work Order ID: 71008

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 3.00

Required Qty: 3.00

D2809

Manufactured No

150 Each

22.0000

1

3



Bushing



*EP 11/06/23*

Location

Loc Qty

Loc Code

ST

10

70805

10

ST023

12

34035

12

*2*

MS21043-3

Purchased No

150 Each

1,215.000

2

6



Nut



*EP 11/06/23*

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1143

112314

143

118077

1000

*4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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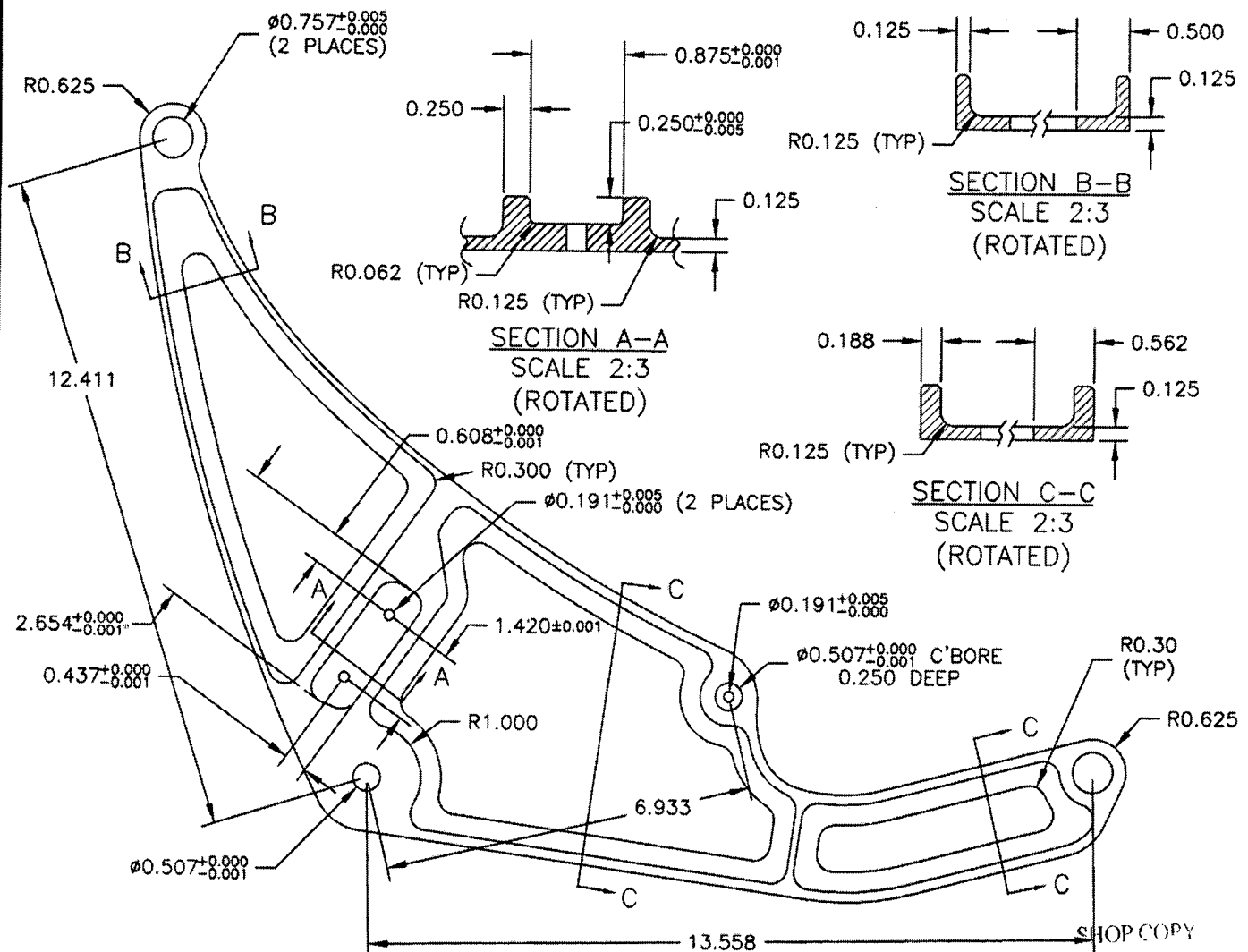
**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 71008  
11-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

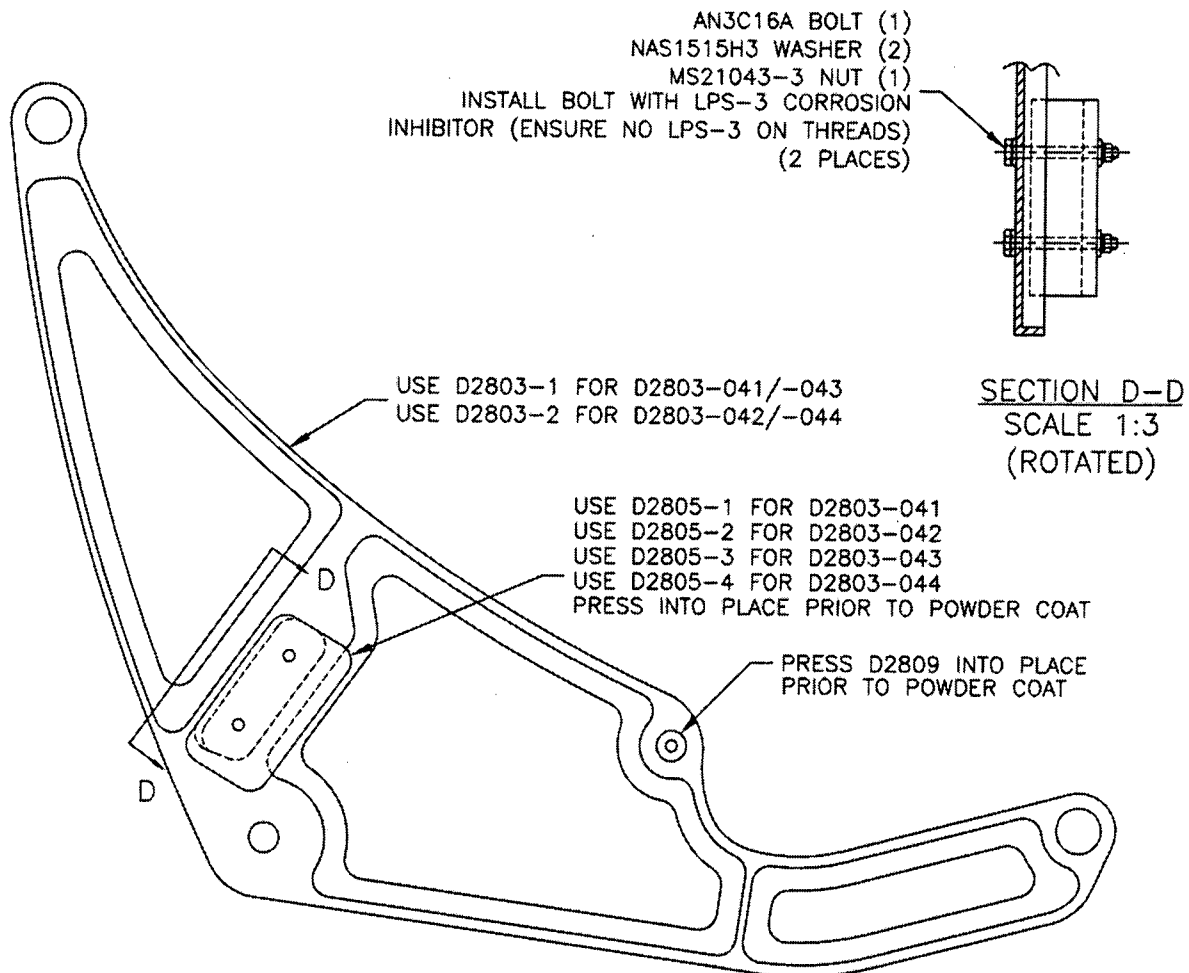
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3

*u/o 71008***RELEASED**05-03.11 *[Signature]*

**D2803-041/-043 BRACKET ASS'Y (SHOWN),**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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